

## **CORRIGENDUM**

**Tender ID: 2023\_BHEL\_23435\_1**

**Tender Reference Number: E5123245, BEARING ASSY COMPONENTS KIT**

**Earlier item description in the NIT was as below:**

**Description: RATE CONTRACT FOR BEARING ASSY COMPONENTS KIT (1 SET=12 ITEMS) CONSISTING OF**

- (1) **1 NOS** END SHIELD DE DRG NO. 14454305051 REV 03
- (2) **1 NOS** OUTER BEARING CAP DE DRG NO. 34454305051 REV 03
- (3) **1 NOS** OUTER LABYRINTH RING DE DRG NO. 34454305052 REV 02
- (4) **1 NOS** INNER LABYRINTH RING DE DRG NO.34454305053 REV 02
- (5) **1 NOS** COVER DE DRG NO. 34454305054 REV 02
- (6) **1 NOS** END SHIELD NDE DRG NO.14454405051 REV 01
- (7) **1 NOS** SPEED PROBE HOUSING NDE DRG NO. 14454405052 REV 00
- (8) **1 NOS** CLAMP PLATE NDE DRG NO. 34454405051 REV 00
- (9) **1 NOS** OUTER BEARING CAP NDE DRG NO. 34454405052 REV 02
- (10) **1 NOS** INNER LABYRINTH RING NDE DRG NO. 34454405053 REV 02
- (11) **1 NOS** BEARING HOUSING NDE DRG NO. 34454405054 REV 02
- (12) **2 NOS** GREASE NIPP LE DRG NO. 44451503007 REV 00.

**Corrigendum has been issued to modify the item description. Now item description in all the NIT documents (including BOQ also) shall be read as below;**

**Description: RATE CONTRACT FOR BEARING ASSY COMPONENTS KIT (1 SET=12 ITEMS) CONSISTING OF**

- (1) 1 NOS END SHIELD DE DRG NO. 14454305051 REV 03
- (2) 1 NOS OUTER BEARING CAP DE DRG NO. 34454305051 REV 04
- (3) 1 NOS OUTER LABYRINTH RING DE DRG NO. 34454305052 REV 02
- (4) 1 NOS INNER LABYRINTH RING DE DRG NO. 34454305053 REV 02
- (5) 1 NOS COVER DE DRG NO. 34454305054 REV 03
- (6) 1 NOS END SHIELD NDE DRG NO. 14454405051 REV 02
- (7) 1 NOS SPEED PROBE HOUSING NDE DRG NO. 14454405052 REV 01
- (8) 1 NOS CLAMP PLATE NDE DRG NO. 34454405051 REV 00
- (9) 1 NOS OUTER BEARING CAP NDE DRG NO. 34454405052 REV 02
- (10) 1 NOS INNER LABYRINTH RING NDE DRG NO. 34454405053 REV 02
- (11) 1 NOS BEARING HOUSING NDE DRG NO. 34454405054 REV 03
- (12) 2 NOS GREASE NIPPLE DRG NO. 44451503007 REV 00

Revised drawings as per above corrigendum are also attached.

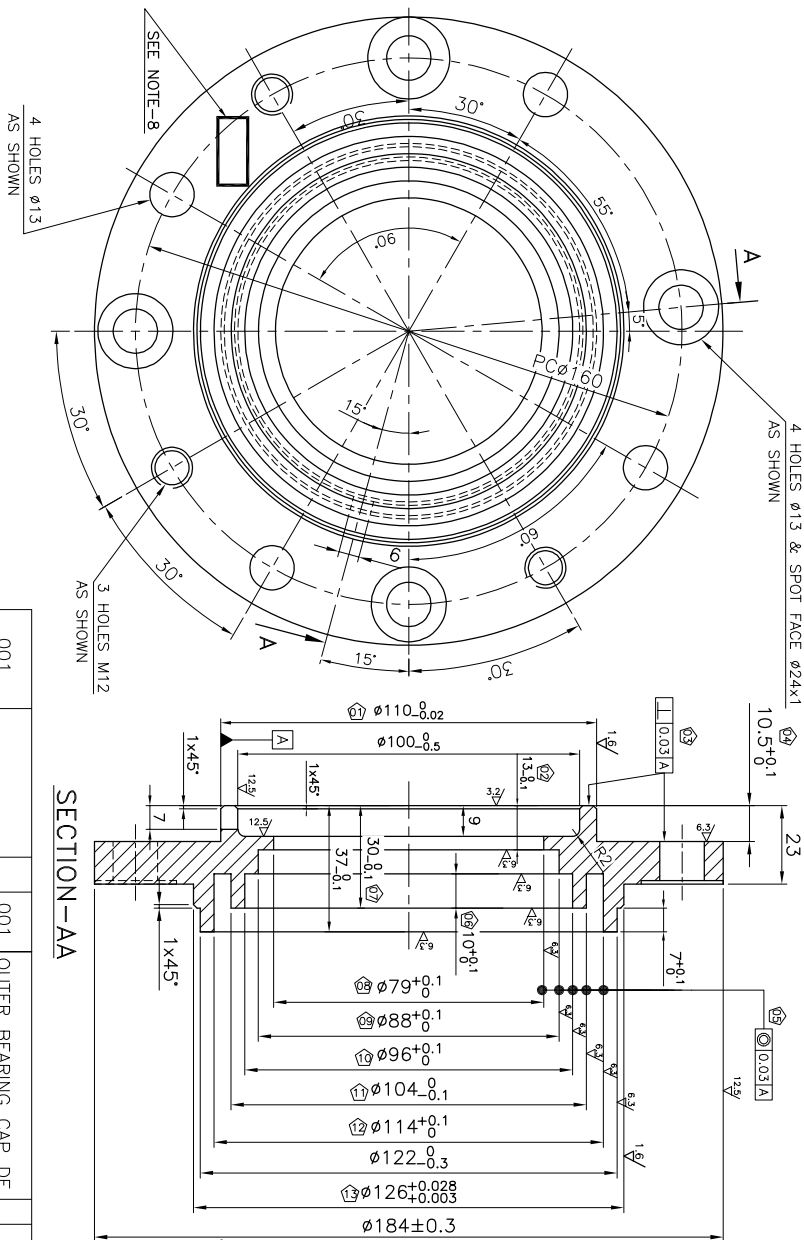
FIRST ANGLE PROJECTION

34454305051

DRG. NO.

(ALL DIMENSIONS ARE IN mm)

TOOL LIST		DESCRIPTION	IT NO.
1608033	TOOL NO.	DRILL JIG FOR 5 X Ø13 @ Ø165	
1608034		"I" TYPE CALIPER GAUGE 141±0.1/0	
1608035		"I" TYRE PIN GAUGE 122±0.1/0	
1608036		PIN GAUGE 101±0.1/0	
1608037		PIN GAUGE 80±0.1/0	
1608038		CALIPER GAUGE 144±0.052/4-0.027	
1608039		FACE GROOVING TOOL FIG - 1/82.3/4 OF SK-745 AP=5, A2±12, Ø111-122	
1608040		FACE GROOVING TOOL FIG - 1/22.3/4 OF SK-745 AP=13, A2±12, Ø111-122	
1608118		AP-13 CORNER RAO = 2, A2±Ø10, Ø90-116 CALIPER GAUGE 191±0.5	



SECTION-AA

- NOTES:**
1. CASTING TO BE STRESS RELIEVED & SHOT BLASTED.
  2. MACHINING ALLOWANCES TO BE MAINTAINED 5<sup>th</sup> OVER EVERY TOOL POINT.
  3. CASTING RAW MATERIAL SHALL BE FROM CLASS 'A' FOUNDRY (AS PER IS:12117-1996). FOR DETAILS REFER SL. NO.1 OF QAP FOR CASTING: QTM/QAP/VENDOR/13-14/001 (LATEST REV.).
  4. TEMPORARY RUST PREVENTIVE (TRP) TO BE APPLIED ON MACHINED SURFACES AS PER AAS5152.
  5.  $\frac{1}{2}$  ALL OVER EXCEPT OTHERWISE STATED, REMOVE SHARP CORNERS.
  6. ALL SHARP EDGES TO BE CHAMFERED TO 0.2-0.3x45°.
  7. ALL 13 NOS. " $\nabla$ " MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL.NO. OF CTQ DIMENSIONS ARE INSCRIBED IN  $\nabla$  e.g. 13.
  8. IDENTIFICATION MARKING TO BE DONE AS PER TM12548 AT THE LOCATION SHOWN.
  9. QUALITY CHECKING OF OUTER BEARING CAP DE TO BE DONE AS PER TM12545.

[illegible]

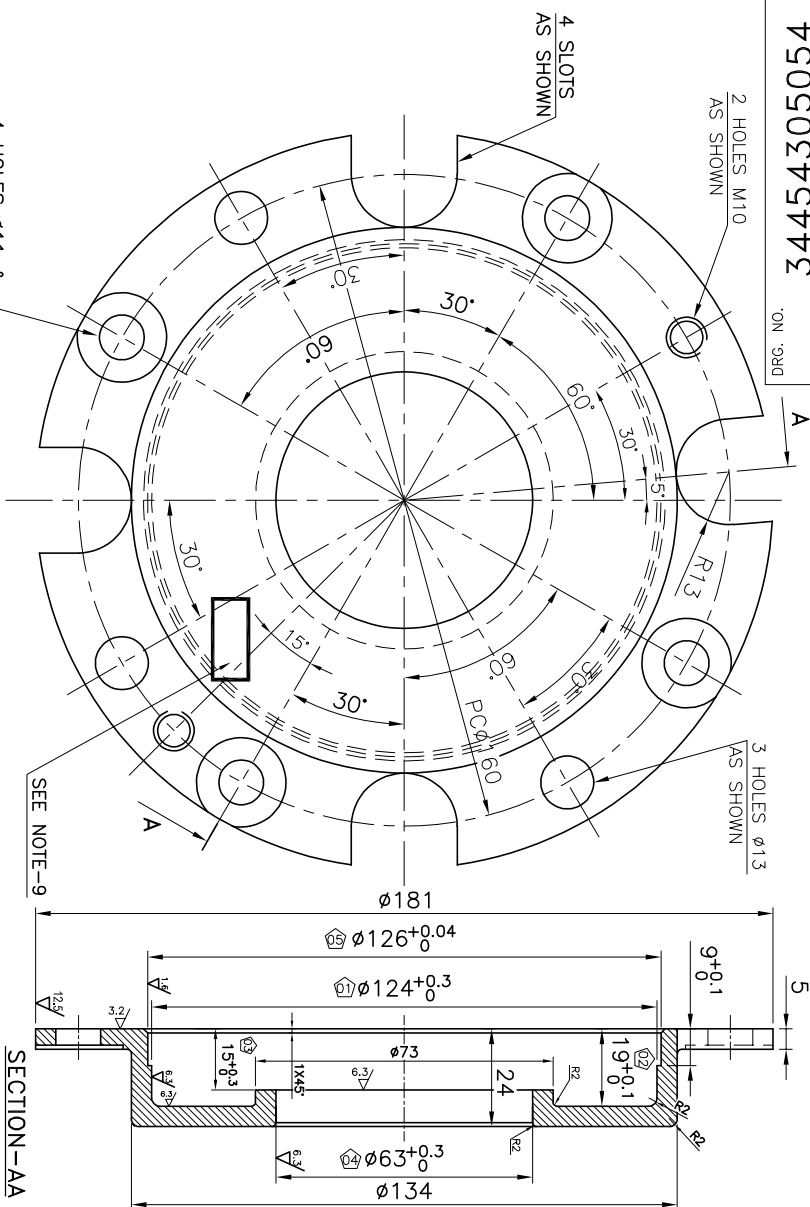
SIZE A3

FIRST ANGLE PROJECTION




(ALL DIMENSIONS ARE IN mm)

34454305054

DRG. NO.



SECTION-AA

- ## NOTES:-
1. ADDITIONAL MATERIAL SHALL NOT BE PROVIDED ON SURFACE WHERE MACHINING SYMBOL IS NOT INDICATED. TOLERANCE ON UNTOLERATED CASTING SURFACE SHALL BE AS PER IS:4897, CLASS-2.
  2. CASTING TO BE STRESS RELIEVED & SHOT BLASTED.
  3. MACHINING ALLOWANCES TO BE MAINTAINED  $5^{+0}_{-0.2}$  OVER EVERY TOOL POINT.
  4. UNSPECIFIED CASTING RADI TO 4 MM.
  5. CASTING RAW MATERIAL SHALL BE FROM CLASS 'A' FOUNDRY (AS PER IS:12117-1996). FOR DETAILS REFER SL. NO.1 OF QAP FOR CASTING: QTM/QAP/VENDOR/13-14/001 (LATEST REV.).
  6. TEMPORARY RUST PREVENTIVE (TRP) TO BE APPLIED ON MACHINED SURFACES AS PER AA55152.
  7. <sup>12.5</sup>ALL OVER EXCEPT OTHERWISE STATED, REMOVE SHARP CORNERS.
  8. ALL SHARP EDGES TO BE CHAMFERED TO 0.2-0.3x45°.
  9. IDENTIFICATION MARKING TO BE DONE AS PER TM12548 AT THE LOCATION SHOWN.
  10. TEMPORARY RUST PREVENTIVE (TRP) TO BE APPLIED ON MACHINED SURFACES AS PER AA55152.
  11. COVER DE TO BE PRIMER PAINTED ON UNMACHINED SURFACES WITH INORGANIC ETHYL ZINC (AA56113) AS PER SCHEME NO. 8 OF TABLE-II (o) OF SPEC. AA0674123 (PAGE NO. 22 OF 30).
  12. ALL 5 NOS. " MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL.NO. OF CTQ DIMENSIONS ARE INSCRIBED IN  e.g. .

4 HOLES Ø11 & 1 HOLES Ø12									
SPOT FACE Ø22x1									
AS SHOWN									
SIGN. & DATE									
REF. DRG. NO.									
INVENTORY NO.									
REV 03 DATE 10.04.23 ALTERED A.J. [Signature] CHECKED A.S. [Signature] APPROVED A.S. [Signature]									
IN SEC.-AA, DIM. 126 AND 9 ADDED AND VIEW UPDATED. 2 HOLES M10 ADDED.									
REV 02 DATE 26.03.23 ALTERED A.J. [Signature] CHECKED A.S. [Signature] APPROVED A.S. [Signature]									
4 SLOTS WERE 5 SLOTS. 3 HOLES Ø13 WERE Ø12. IN SEC.-AA, DIM. 73 & 15 ADDED AND VIEW UPDATED. NOTE-12 ADDED.									
REV 01 DATE 03.03.23 ALTERED A.J. [Signature] CHECKED A.S. [Signature] APPROVED A.S. [Signature]									
3 HOLES Ø12 ADDED.									
TITLE COVER DE (CNC MACHINED)									
DEPT. TME GRADE OF UNTOOL. DIM. Ø/M/P CODE 405 AA0230208									
SCALE NTS WEIGHT (kg) 1.0									
REF. TO ASSY. DRG. 24454305051									
ITEM NO. 001									
NO. OF ITEMS 001									
REV. 03									
SHEET NO. 01 NO. OF SHEET 01									
DRAWING NO. 34454305054									
IM3004AZ									
NAME OF CUSTOMER/PROJECT									
TYPE OF PRODUCT OR									
STATUS OF DRAWING									
DISTRIBUTION OF PRINT TME-1 TNX-1 TXM-4									
BHARAT HEAVY ELECTRICALS LTD. BHOPAL									
A.J.HARIA [Signature] 04.02.23									
A.SHARMA [Signature] 04.02.23									
A.SHARMA [Signature] 04.02.23									
NO. OF VAR 01									
MATL. CODE A A19721									
UNIT WT. 0.00									
QTY. 01									
ZONE									

SIZE A3

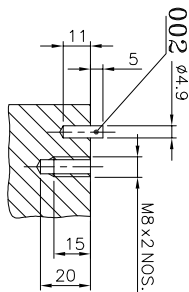
INVENTORY NO.																					
REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	
CHECKED			CHECKED			CHECKED			CHECKED			CHECKED			CHECKED			CHECKED			
APPROVED			APPROVED			APPROVED			APPROVED			APPROVED			APPROVED			APPROVED			
ZONE		ZONE		ZONE		ZONE		ZONE		ZONE		ZONE		ZONE		ZONE		ZONE		ZONE	
<div>END SHIELD NDE (CNC MACHINED)</div> <div>DRUMING NO. 1 445 44 05 051 021</div> <div>SHT. NO. 01 NO. OF SHT. 0</div>																					

(ALL DIMENSIONS ARE IN MM)

FIRST ANGLE PROJECTION

2500 50 574 1 ON 380

IT NO.	TOOL NO.	DESCRIPTION
001	1606193	PIN GAUGE 235±0.046/0
001	1606194	DRILL JIG FOR (3+1)XØ20
001	1606195	DRILL JIG FOR 4.9 & 2MM
001	1528008	M8 HOLES FOR SEC - BB
001	1605093	GAUGE FOR CHECKING SPEED SENSOR FITMENT POSITION



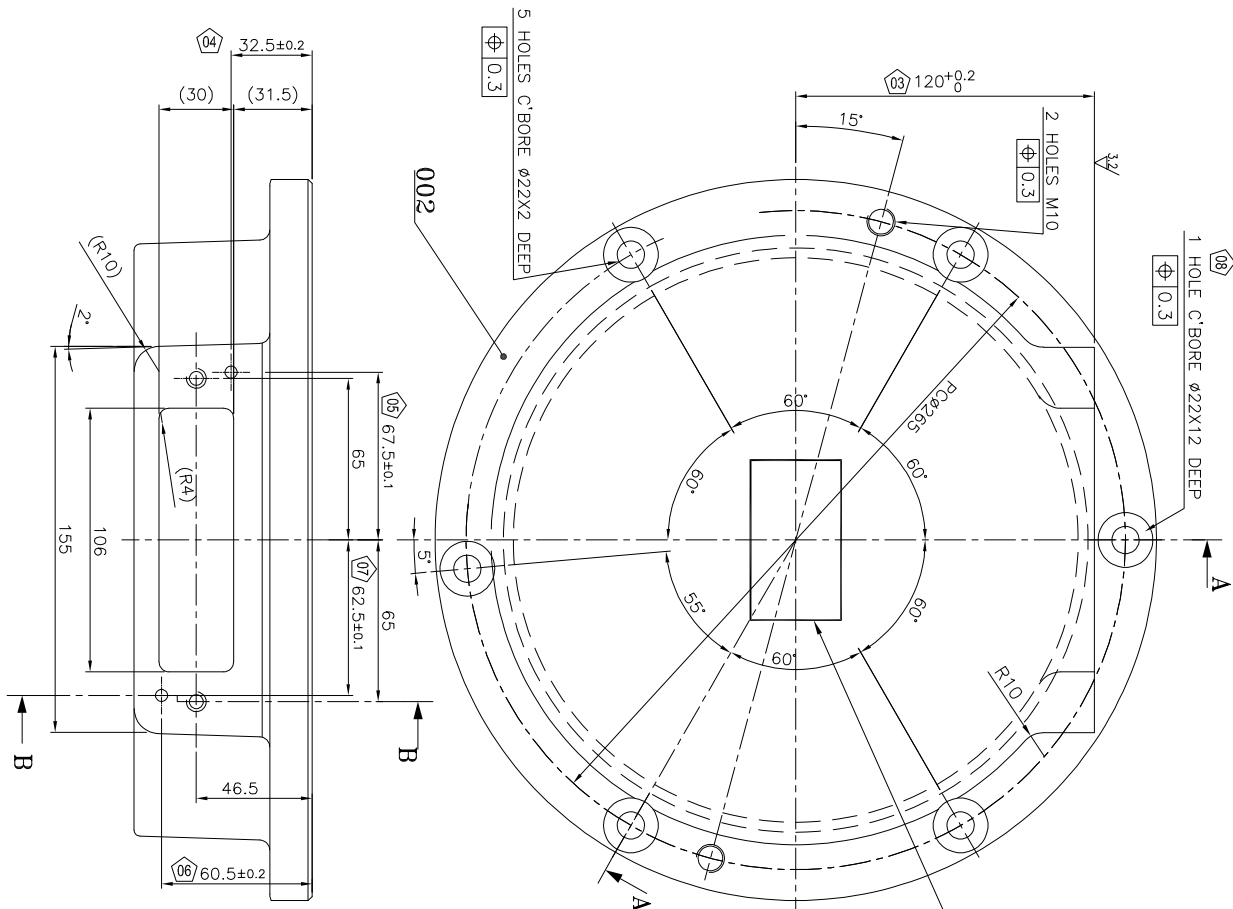
SECTION B-B

LOCATION OF  
EMBROSSING & MARKING  
(SEE NOTE-06)

NOTES:-

1. CASTING RAW MATERIAL SHALL BE FROM CLASS 'A' FOUNDRY (AS PER IS:12117-1996). FOR DETAILS REFER SL. NO. 1 OF QAP FOR CASTING: QTM/QAP/VEENDOR/13-14/001 (LATEST REVISION).
2. ADDITIONAL MATERIAL SHALL NOT BE PROVIDED ON SURFACE WHERE MACHINING SYMBOL IS NOT INDICATED. TOLERANCE ON UNTOLERATED CASTING SURFACE SHALL BE AS PER IS:4897 CLASS-2.
3. MACHINING ALLOWANCES TO BE MAINTAINED  $5 \pm 0$  OVER EVERY TOOL POINT.
4. CASTING TO BE STRESS RELIEVED & SHOT BLASTED.
5. UNSPECIFIED CASTING RADI TO 4 MM.
6. IDENTIFICATION MARKING OF SPEED PROBE HOUSING TO BE DONE AT THIS LOCATION AS PER SPECIFICATION TM12548.
7. ALL SHARP EDGES TO BE CHAMFERED TO 0.2-0.3x45°.
8. ALL 08 NOS. "O" MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSIONS ARE INSCRIBED IN  $\square$  e.g. 008.
9. TEMPORARY RUST PREVENTIVE (TRP) TO BE APPLIED ON MACHINED SURFACES AS PER A455152.
10. QUALITY CHECKING OF SPEED PROBE HOUSING TO BE DONE AS PER TM12545.
11. SPEED PROBE HOUSING TO BE PRIMER PAINTED ON UNMACHINED SURFACES WITH INORGANIC ETHYL ZINC (A456113) AS PER SCHEME NO. 8 OF TABLE-II (a) OF SPEC. A40674123 (PAGE NO. 22 OF 30).

SECTION A-A



REV	DATE	DESCRIPTION	BY	CHKD	APP'D	DATE
001	10.04.23	APPROVED AS PER SPEC	001	001	001	001
002	10.04.23	APPROVED AS PER SPEC	002	002	002	002

REV	DATE	DESCRIPTION	BY	CHKD	APP'D	DATE
001	10.04.23	APPROVED AS PER SPEC	001	001	001	001
002	10.04.23	APPROVED AS PER SPEC	002	002	002	002

REV	DATE	DESCRIPTION	BY	CHKD	APP'D	DATE
001	10.04.23	APPROVED AS PER SPEC	001	001	001	001
002	10.04.23	APPROVED AS PER SPEC	002	002	002	002

REV	DATE	DESCRIPTION	BY	CHKD	APP'D	DATE
001	10.04.23	APPROVED AS PER SPEC	001	001	001	001
002	10.04.23	APPROVED AS PER SPEC	002	002	002	002

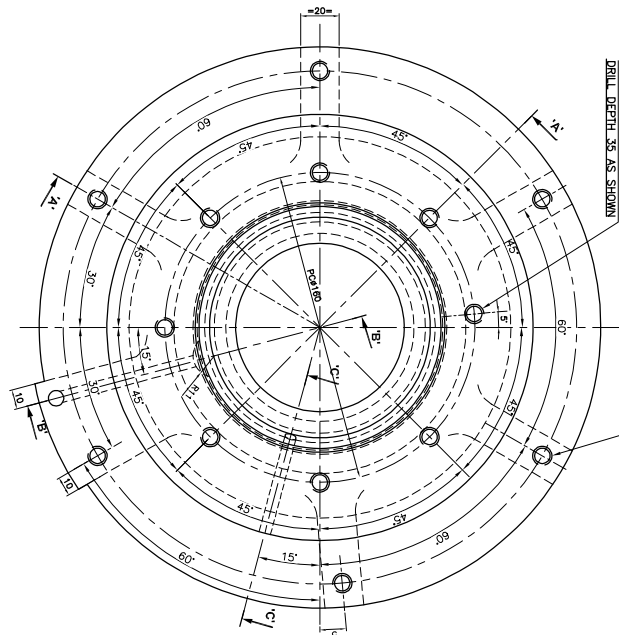
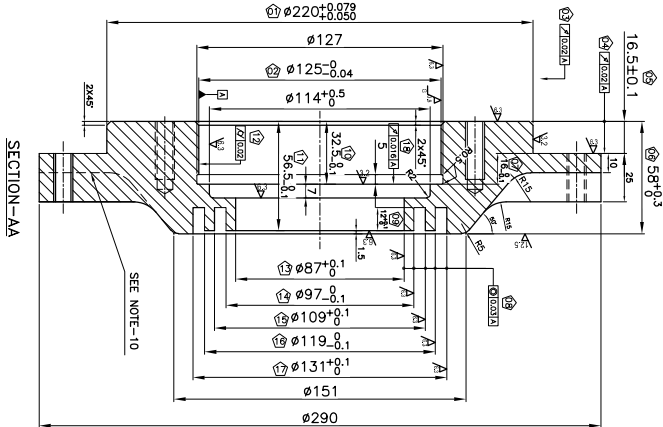
SIZE A1

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

45050445054

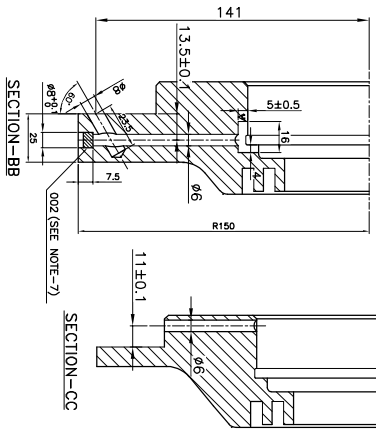
DRG. NO.



- NOTES:-
1. ADDITIONAL MATERIAL SHALL NOT BE PROVIDED ON SURFACE WHERE MACHINING SYMBOL IS NOT INDICATED.
  2. CASTING TO BE STRESS RELIEVED & SHOT BLASTED.
  3. UNSPECIFIED CASTING RADI TO 4 MM.
  4. BEARING HOUSING NDE TO BE PRIMER PAINTED ON UNMACHINED SURFACES WITH INORGANIC ETHYL ZINC (A568113) AS PER SCHEME NO. 8 OF TABLE-II (a) OF SPEC. AA06/4123 (PAGE NO. 22 OF 30).
  5. MACHINING ALLOWANCES TO BE MAINTAINED 5<sup>th</sup> OVER EVERY TOOL POINT.
  6. ALL SHARP EDGES TO BE CHAMFERED TO 0.2-0.3x45°.
  7. ITEM NO. 002 TO BE PLUGGED & WELDED AT LOCATION THE LOCATION SHOWN.
  8. QUALITY CHECKING OF BEARING HOUSING NDE TO BE DONE AS PER TM12545.
  9. ALL NOS. "O" MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSIONS ARE INSCRIBED IN Q.e.g. 10.
  10. IDENTIFICATION MARKING OF BEARING HOUSING NDE TO BE DONE AS PER TM12548 AT THE LOCATION SHOWN.
  11. TEMPORARY RUST PREVENTIVE (TRP) TO BE APPLIED ON MACHINED SURFACES AS PER AA05152.
  12. CASTING RAW MATERIAL SHALL BE FROM CLASS 'A' FOUNDRY (AS PER IS:1217-1998). FOR DETAILS REFER SL. NO.1 OF QAP FOR CASTING: QM/QAP/VERSION/15-14/001 (LATEST REL.).

### TOOL LIST

IT.NO.	TOOL NO	DESCRIPTION
1608074		DRILL JIG FOR 7XM10@265 + 7XM10@145
1608075		DRILL JIG FOR ANGULAR HOLE 31° & 90° WITH ANGLE PLATE
1608076		FACE GROOVING TOOL FIG - 1/2/3/4 OF SK-745 AP=6 A=12. 077-113
1608077		1" TYPE CALIPER GAUGE 77-0.1/0 45
1608078		1" TYPE CALIPER GAUGE 98.5-0.1/0
1608079		1" TYPE PIN GAUGE 89+0.1/0
1608080		1" TYPE PIN GAUGE 112.5+0.1/0



SECTION-CC

DISTRIBUTION OF PRINT  
TME-1 TNX-1  
TXM-4



BHARAT HEAVY ELECTRICALS LTD.  
BHOPAL

IM3004AZ

ADDITION INFORMATION

TYPE OF PRODUCT  
OR  
NAME OF CUSTOMER/PROJECT

IM3004AZ

VAR	NO	REMARKS	VAR	ITEM NO.	DESCRIPTION	DRAWING NO.	VAR	ITEM NO.	MATL. CODE	MATL. SPECN.	UNIT	WT.	QTY.	ZONE
001			001		BEARING HOUSING NDE									
001			001		BEARING HOUSING NDE									

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.	REV	DATE	ALTERED	A.J.	REV	DATE	ALTERED	A.J.	DEPT.	GRADE OF UNTOOL	SCALE	WEIGHT (kg)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS	REV.
03	10.04.23		02	26.03.23			01	03.03.23			405	AA0230208	NTS	12.4	24454405051	004	001	03
ZONE 9 HOLES M10 WERE 7 HOLES M10. IN SEC.-BB, DIM. 4 ADDED. IN SEC.-AA, RINOUT DIM. ON BEARING SITTING FACE ADDED. TOL. ON DIM. 16 CHANGED FROM (+/-0.1) TO (+/-0.1) ADDED ON 1114 AND CH. 2445 WAS 1x45.			ZONE 8 HOLES M10 WERE 7 HOLES M10. IN SEC.-BB, DIM. 4 ADDED. IN SEC.-AA, RINOUT DIM. ON BEARING SITTING FACE ADDED. TOL. ON DIM. 16 CHANGED FROM (+/-0.1) TO (+/-0.1) ADDED ON 1114 AND CH. 2445 WAS 1x45.			BEARING HOUSING NDE (CNC MACHINED)			DRAWING NO. 34454405054			SHEET NO. 01			NO. OF SHEET 01			03

SIZE A3